

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-022012**Date Inspected:** 22-Feb-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Lv Li Qing**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance(QA) Inspector Mr.Shrikant Utekar was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. The QA Inspector observed and/or found the following:

BAY # 14

This QA Inspector randomly observed the following work in progress.

OBG 14EAST

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 066179 performing the Shielded Metal Arc Welding process on weld 137 located at PCMK SEG3019AB. ZPMC QC Mr. Zhong Guo Hui was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-Tc-u5b-Fcm.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 067079 performing the Flux Cored Arc Welding process on weld 253 located at PCMK SEG3019K. ZPMC QC Mr. Zhong Guo Hui was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-2233-ESAB.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 066733 performing the Flux Cored Arc

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Welding process on weld 026 located at PCMK SEG3019S. ZPMC QC Mr. Zhong Guo Hui was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-2233-ESAB.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 066763 performing the Flux Cored Arc Welding process on weld 025 located at PCMK SEG3019BB. ZPMC QC Mr. Zhong Guo Hui was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-345-FCAW-3G (3F)-ESAB-Repair. Weld repair report identified as B-WR20270.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 066439 performing the Flux Cored Arc Welding process on weld 172 located at PCMK SEG3019P. ZPMC QC Mr. Zhong Guo Hui was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-345-FCAW-3G (3F)-ESAB-Repair. Weld repair report identified as B-WR20247.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 054013 performing the Shielded Metal Arc Welding process on weld 169 located at PCMK SEG3019BB. ZPMC QC Mr. Zhong Guo Hui was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-2G (2F)-Fcm-Repair-1. Critical weld repair report identified as B-CWR2737.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 037748 performing the Shielded Metal Arc Welding process on weld 014 located at PCMK SEG3019BC. ZPMC QC Mr. Zhong Guo Hui was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-P-2114- Fcm-1.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 044824 performing the Flux Cored Arc Welding process on weld 019 located at PCMK SA3358-001. ZPMC QC Mr. Zhong Guo Hui was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-2232-ESAB.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 066326 performing the Shielded Metal Arc Welding process on weld 162 located at PCMK SEG3019D-2. ZPMC QC Mr. Zhong Guo Hui was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-2G (2F)-Fcm-Repair-1. Weld repair report identified as B-WR20273.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 037748 performing the Shielded Metal Arc Welding process on weld 007 located at PCMK SEG3019BB. ZPMC QC Mr. Zhong Guo Hui was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-P-2114-Fcm-1.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 066439 performing the Flux Cored Arc Welding process on weld 021 located at PCMK SEG3019BB. ZPMC QC Mr. Zhong Guo Hui was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-2232-ESAB.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 044824 performing the Flux Cored Arc Welding process on weld 013 located at PCMK SEG3019BC1. ZPMC QC Mr. Zhong Guo Hui was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-2132-ESAB.

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This Quality Assurance (QA) Inspector observed ZPMC qualified welder 054013 performing the Shielded Metal Arc Welding process on weld 125 located at PCMK SEG3019BB. ZPMC QC Mr. Zhong Guo Hui was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-2G (2F)-Fcm-Repair-1. Critical weld repair report identified as B-CWR2737.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 068917 performing the Shielded Metal Arc Welding process on weld 013 located at PCMK FB3271-001. ZPMC QC Mr. Zhong Guo Hui was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-P-2114-Fcm-1.

This Quality Assurance (QA) Inspector observed ZPMC personnel performing heat straightening, member identified as Anchorage plate AP3007. Distortion appeared to be caused by welding. Weld number identified as SEG3019Z-004~008. ZPMC Quality Control (QC) inspector identified as Mr. Xie Ming Feng was present to monitor the heat straightening process. The heat straightening appeared to comply with heat straightening Report HSR1 (B)-10117.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



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Summary of Conversations:

No significant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, +(86) 1500 042 2372, who represents the Office of Structural Materials for your project.

Inspected By:	Utekar,Shrikant	Quality Assurance Inspector
Reviewed By:	Patterson,Rodney	QA Reviewer
